

628-03

Date: Friday, 1/25/2008 10:48:59 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B FLOAT STEP ASSY, LH
 Job Number : 36963A
 Estimate Number : 11662
 P.O. Number :
 This Issue : 1/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2841041
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Number : D2841 REV B
 Previous Run : 36078A Project Number : N/A
 Material :
 Due Date : 3/10/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : 080125
 Comment : Est Rev.D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part # Description Batch:
 1 D2622-120C Extrusion B36923

Check Material for any Dents or Defects

SAD 08/03/17 (4)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2841-1 using D2622 extrusion as per Dwg D2841

2-Drill extrusion per drawing D2841 using Jig DT 8265

3-Deburr and bevel ends for welding

SAD 08/03/17 (4)

08-03-18

08-03-18

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SAD 08/03/17 (4)

4.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch:
 2 D2734 End Cap 336520

08-03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:49:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FLOAT STEP ASSY, LH

Job Number: 36963A

Part Number: D2841041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34641

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lug

Pick:

Qty	Part Number	Description	Batch
1	D3464-1	Plate	325425

PH 08.03.19

4

6.0

D34643

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-3	Plate	325426

PH 08.03.19

4

7.0

D34645

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-5	Plate	325427

PH 08.03.19

4

8.0

D34647

mounting plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3464-7	Plate	325428

PH 08.03.19

4

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

1-Weld end cap(AFT END ONLY) and lugs as per Dwg D2841

using Jig DT 8267 followed by DT 8268

A/R AL ROD

Batch:

M106734
M106762

2-Grind end cap welds flush

PH 08.03.25
PH 08.03.25
SAP 08/03/27

4

4

4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 206B FLOAT STEP ASSY, LH

Job Number: 36963A

Part Number: D2841041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 08-03-27 (1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/27 (4)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten initials

08-03-28

(x4)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/03/28 (x4) CH

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remaining end cap as per Dwg D2841

Grind

A/R AL ROD

Batch: M106834

08-04-01

08-04-01

4
4
PTO

15.0

QC10

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-03-02

08/04/02

(x4) CH

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/02

(x4) CH

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine & Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

08-04-02

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-04-02	14b.	grind end caps flush as per drawing. 2841	JL	08-04-02	4		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 36963A

Part Number: D2841041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FJ 08/04/03 (4)

19.0

NAS1329C3KB130

insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

4

NAS1329C3KB130

Insert

m106951

FJ

20.0

MS27039C107

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4

MS27039C1-07

Screw

m107008

FJ

21.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4

NAS1515H3L

WASHER

m106516

FJ

22.0

AN960C10L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4

AN960C10L

WASHER

m107008

FJ

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch:

m107385

FJ 08/04/03 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36963A

Part Number: D2841041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/07

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Rev F

08/04/07

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08
(X4)

Job Completion



mf 08-04-07

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

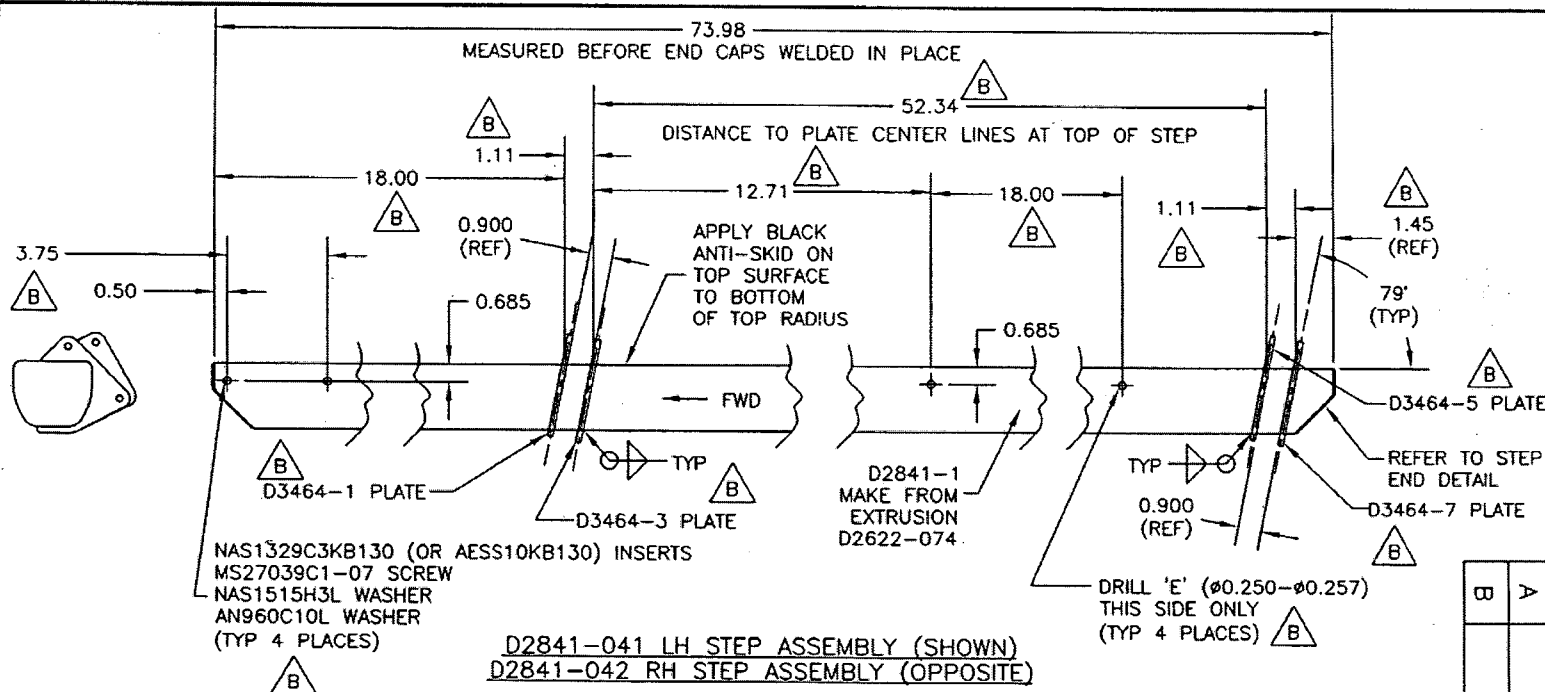
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART



D2841-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2841-041	LH STEP ASSEMBLY
	X	D2841-042	RH STEP ASSEMBLY
1	1	D2822-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 504

D2841²-041/-042 STEP ASSEMBLY

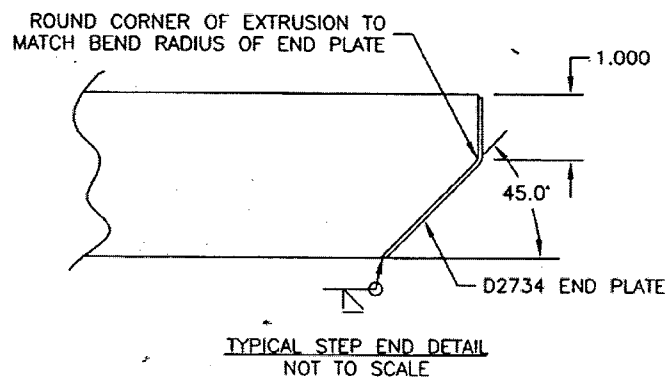
MAKE FROM EXTRUSION D2622

WELD PER DART QSI 004

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

ALL DIMENSIONS ARE IN INCHES

ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED
05-11-14

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WITHOUT NOTICE
WORK ORDER
NO. 36963A

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DESIGN KE		DRAWING NO. D2841		REV. B
CHECKED <i>[Signature]</i>		APPROVED <i>[Signature]</i>		SHEET 1 OF 1
DATE 05.09.21		TITLE 206B FLOAT STEP ASSEMBLY		SCALE NTS
A	98.10.14	NEW ISSUE		
B	05.09.21	RE-DESIGN, ADD D2843-1/-3/-5/-7		